

Work Order ID 73467

Thursday, September 01, 2011 7:37:03 AM



Page 1

Item ID:	D3208-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	8/31/2011	Start Qty:	10.00 ¹³	Cust Item ID:		
Required Date:	9/16/2011	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/09/01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3208	Rev A1								

100
 SHEAR
 Shear
 Shear
 Memo
 Cut blank: 4.038" X 5.340" grain along 4.038" ☐ Identify for D3208-1

ES 11/09/16 (18)

110
 Small Fab
 Small Fab
 Small Fab
 Memo
 Drill and Fillet D3208-1 corner as per Dwg D3208 ☐ Identify as D3208-1

ES 11/09/16 (18)

120
 NC BRAKE
 Brake NC
 Brake NC
 Memo
 Deburr D3208-1 ☐ Form D3208-1 as per Dwg D3208 ☐ Polish any marks on part within 01. of Dwg D3208

ES 11/09/22 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73467



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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 u/09/22		(+18)			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				18	0	11-9-26	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				18	16	11-9-26	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3208-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/31/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>201</u> Memo	0.00 0.00				11/9/26 <i>sf</i>		(180)	
170 QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00						11/9/27 <i>sf</i> ME 11-09-27	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:37:00 AM

Page 1

Work Order ID: 73467

Parent Item: D3208-1

Parent Item Name: Doubler



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B□04.05.25□Material changed for Step 4□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

* M2024T3S.040

Purchased

No

100

sf

174.0184

0.1645

1.731579



2024-T3 .040 sheet



ES 11/09/16

Location

Loc Qty

Loc Code

MAT022

174.018421

112291

0.5

112331

0.2

113162

18.1

117684

155.218421

~~174.0184~~ 2.961

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

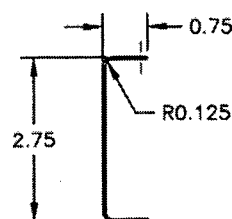
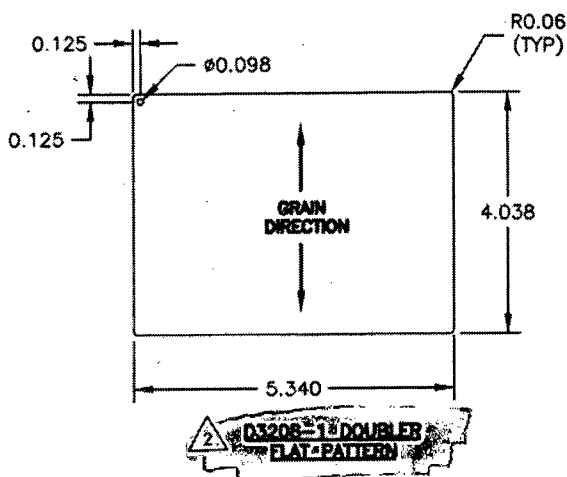
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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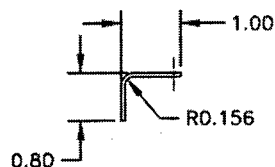
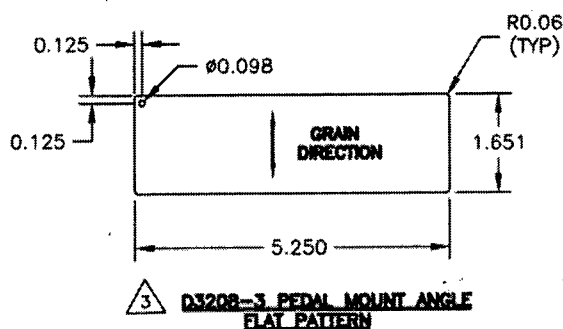


DESIGN RT	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE DOUBLER		SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# RF 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

RELEASED
04.04.05 #



D3208-1 DOUBLER
BEND DETAIL



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73467

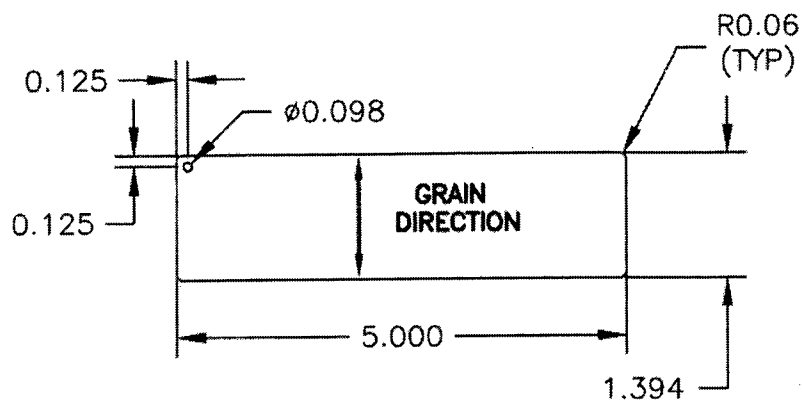
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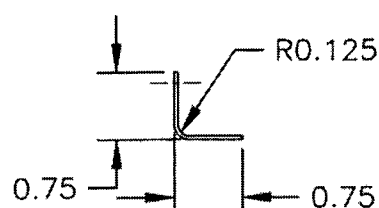
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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.04.05 H

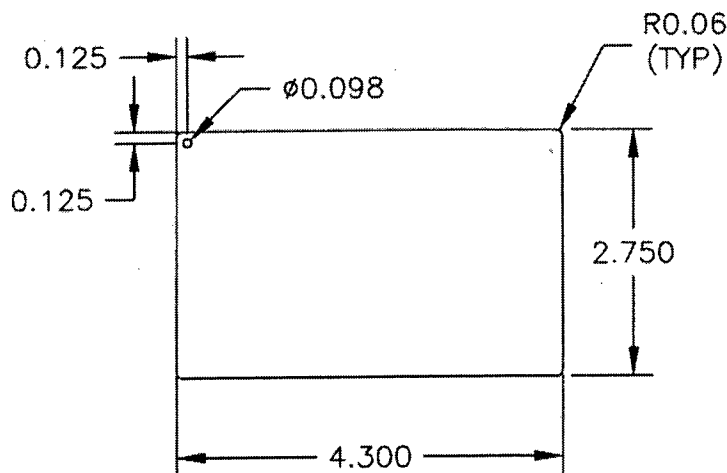


2

**D3208-5 MOUNT ANGLE
FLAT PATTERN**

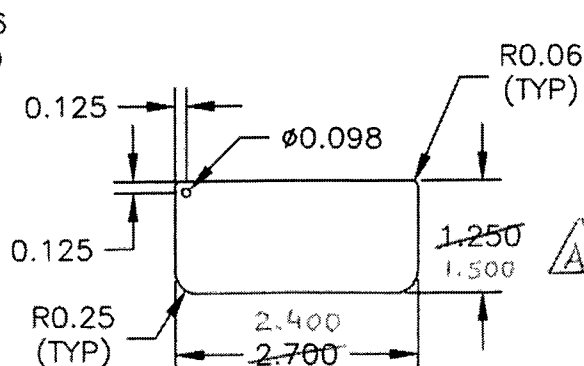


**D3208-5 MOUNT ANGLE
BEND DETAIL**



2

D3208-7 FILLER



2

D3208-11 FILLER

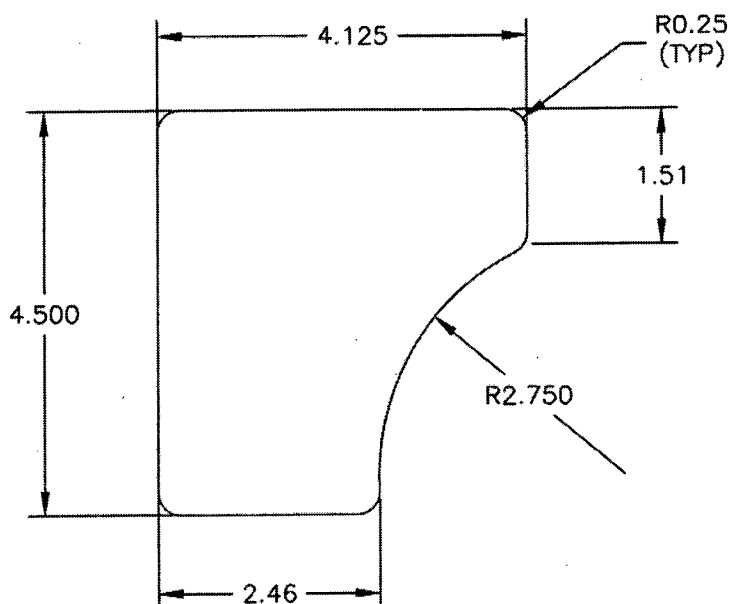
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.08 [Signature]



D3208-9 DOUBLER

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